			REVISION		
			DESCRIPTION	APPROVED	DATE
<u>(A)</u>	TAH	9/20/93	ADDED NOTE 1.		
B	TAH	10/13/93	GENERAL UPDATE CHANGED MAT. SPEC. ON -003,-004 & -005		
0	TAH	11/5/93	GENERAL UPDATE		
0	TAH	11/16/93	GENERAL UPDATE		
(E)	TAH	11/17/93	GENERAL UPDATE		
(Ē)	TAH	11/30/93	GENERAL UPDATE		
©	TAH	12/3/93	GENERAL UPDATE		
Θ	ТАН	4/22/94	ADDED SHT 4 MOVED ANGLES TO SHT 4. ADDED -006 ANGLE TO L/M & SHT 4. REMOVED OUTB'D RIVET HOLES FROM -001 & -002 DOUBLER.		
①	DNN	9/7/94	GENERAL UPDATE		
0	DNN	12/19/95	GENERAL UPDATE	P. SCHWARTZ 96.014 96.015 96.016	3/21/96 3/21/96 3/21/96

N	O F	RFO'D	PFF	RASSY	PART NO.		NAME	STOCK SIZE	MATERIAL	MATL.SPEC	ZONE
					41228-301-034-001	L/H D		0.050"	2024—T3 ALUM. (ALT. MAT'L 2024	QQ-A-250/5 -T3 ALUM.QQ-A-25	50/4) ①
					41228-301-034-002	R/H D	OUBLER	0.050"	2024-T3 ALUM.		
					41228-301-034-003	L/H IN	BD ANGLE	0.032"	2024-T3 ALUM.	QQ-A-250/4B	
		<u> </u>			41228-301-034-004	R/H IN	IBD ANGLE	0.032"	2024-T3 ALUM.	QQ-A-250/4BE	
					41228-301-034-005	R/H O	UTBD ANGLE	0.032"	2024-T3 ALUM.	QQ-A-250/4BE	
		ļ			41228-301-034-006	L/H O	UTBD ANGLE	0.032"	2024-T3 ALUM.	QQ-A-250/4A	

FINISH IN ACCORDANCE WITH ERA PROCESS SPECIFICATION NO. 4003, 4006, & 4004. (A)

NOTE:

	REQ'D PER ASSY				
			UNLESS	DRFTSMN	Bruce
1 41228-300-004			SPECIFIED	CHECK	
1	41228-300-004		XX.±.03	STRESS PROJ.	•
1	41228-300-004		ANGLES	engr. Heat treat	
H RED'D PER ASSY	NEXT ASSEMBLY	MOL	±.1/2	FINISH	Λ
	1 1 1 REDTO PER ASSY	1 41228-300-004 1 41228-300-004	1 41228-300-004 1 41228-300-004	1 41228-300-004 SPECIFIED X.±.1 1 41228-300-004 X.±.01 1 41228-300-004 ANGLES ±.1/2	1 41228-300-004 OTHERWISE SPECIFIED X.±.1 STRESS 1 41228-300-004 XX.±.03 XXX.±.010 ANGLES ±.1/Z H RESTO PER NEXT ASSEMBLY

DRFTSMN	Bruce	Tarver	7/18/93	TITLE		
CHECK					L LINE CAVITY	
STRESS	•			TAIR	RING DOUBLER	
PROJ. ENGR.				DWG. SIZE	SCALE NONE	
HEAT TREAT			I Гил. /	Visiting Inc.	DWG. NO.	REV.
FINISH		/-	Era A	Aviation, inc.	41228-301-034	١,





